

Date: Thursday, 11/06/2009 11:17:53 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 212 BASKET BASE ASS'Y RH
<b>Job Number</b> : 48490B	
<b>Estimate Number</b> : 11543	
<b>P.O. Number</b> :	<b>Part Number</b> : D3053042
<b>This Issue</b> : 11/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3053 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 47573B	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 17/06/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>Julie Dawson</u>	
<b>Comment</b> : Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF Est Rev:D 08-08-29 revB as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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**Comment:** Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)  
 304 SQ Tube.75x.75x.065W

1-Cut Rib from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

Batch: 771113885

2-Drill holes in D3053-3 as per dwg D3053

SAN 09.06.12(D)

2.0	D31661	Basket Hoop
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**Comment:** Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Qty. 5 D3166-1

Batch: 348425 → 4Op 09.06.11

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 11-Cut 5 D2235-3 FROM D3166-1 using DT8365 Op 09.06.112-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995 Op 09.06.11

4.0	D23273	Spacer Bushing
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Pick:

Qty Part Number

Description

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 11/06/2009 11:17:53 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASSY RH

Job Number: 48490B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2327-3

Bushing

✓ 344274

Pl09.06.11

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description

Batch

2 D2232-3

Hinge plate

346949

Pl09.06.15

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

347264

Pl09.06.15

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number

Description

Batch

48sq.ft M304EX0.75-16F

Expanded Metal

111956

SAD 09-06-12 @

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

Pl09.06.15

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11 09.06.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 11/06/2009 11:17:53 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASSY RH

Job Number: 48490B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/06/16 (X)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1st

2ND

START TIME:

8:00AM

9:40 AM

OVEN TEMPERATURE:

400°F

400°F

FINISH TIME:

8:30pm

9:40 AM

09-06-16 (X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/06/16 (X)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

09/06/17

9/6/17

(X)

(X)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/17 (X)

Job Completion



MF 09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

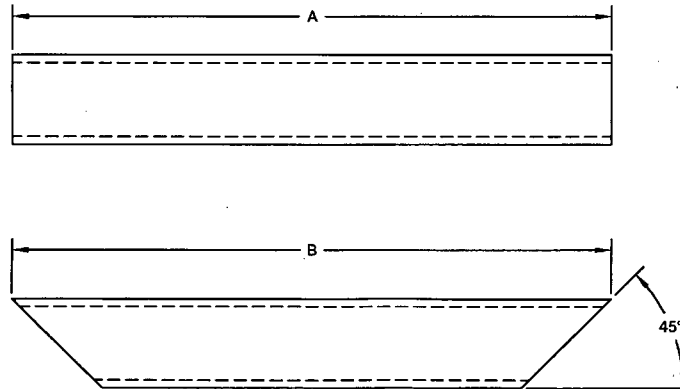
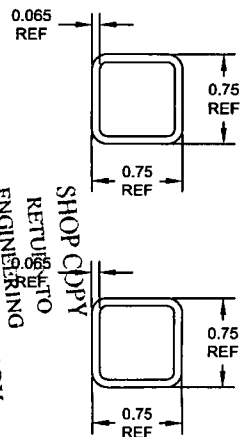
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# **PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



NO. 1119005  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

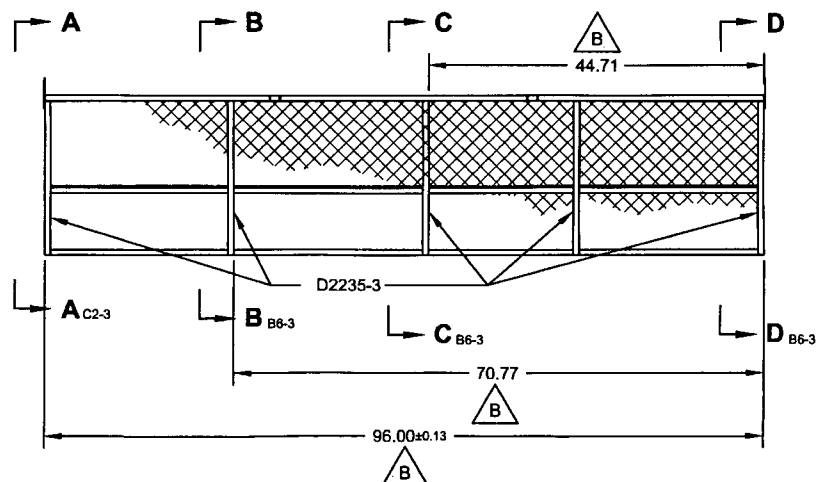
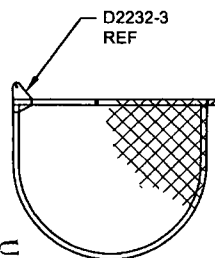
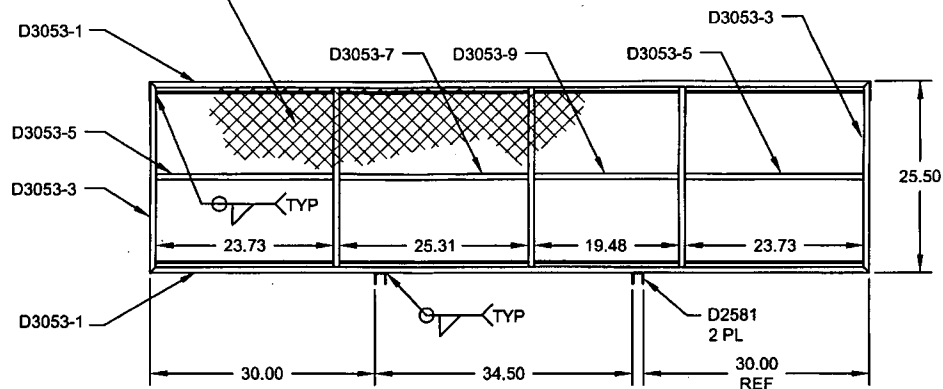


## **NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

**RELEASED**





B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



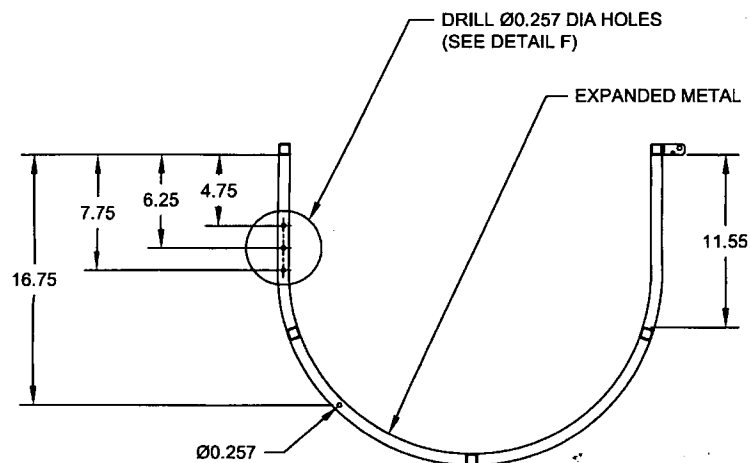
**D3053-042 BASKET BASE ASSEMBLY SHOWN**  
**(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 184905

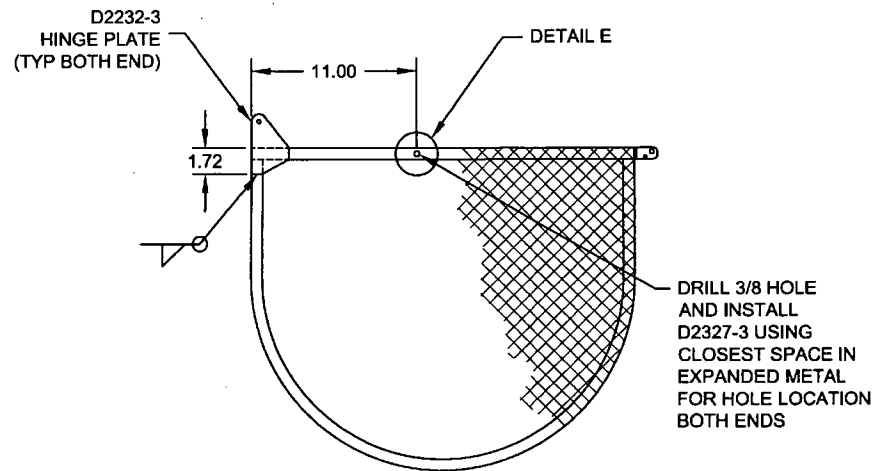
RELEASE  
08-28-21

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212) NTS	
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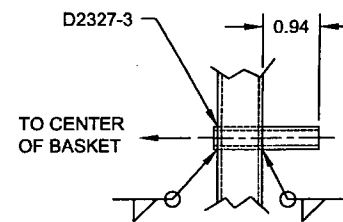




**SECTION B-B**<sub>B5-2</sub>  
**SECTION C-C**<sub>B4-2</sub>  
**AND SECTION D-D**<sub>B3-2</sub>  
 RIB DETAIL

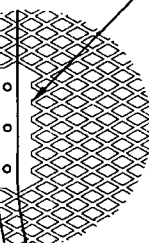


**SECTION A-A**<sub>B6-2</sub>  
 SPACER DETAIL



**DETAIL E**  
 SCALE 4X



CUT AWAY EXPANDED METAL TO NEAREST INTERSECTIONS AS SHOWN SECTION D-D ONLY



**DETAIL F**  
 SCALE NONE

NO. 2848013  
 WORK ORDER  
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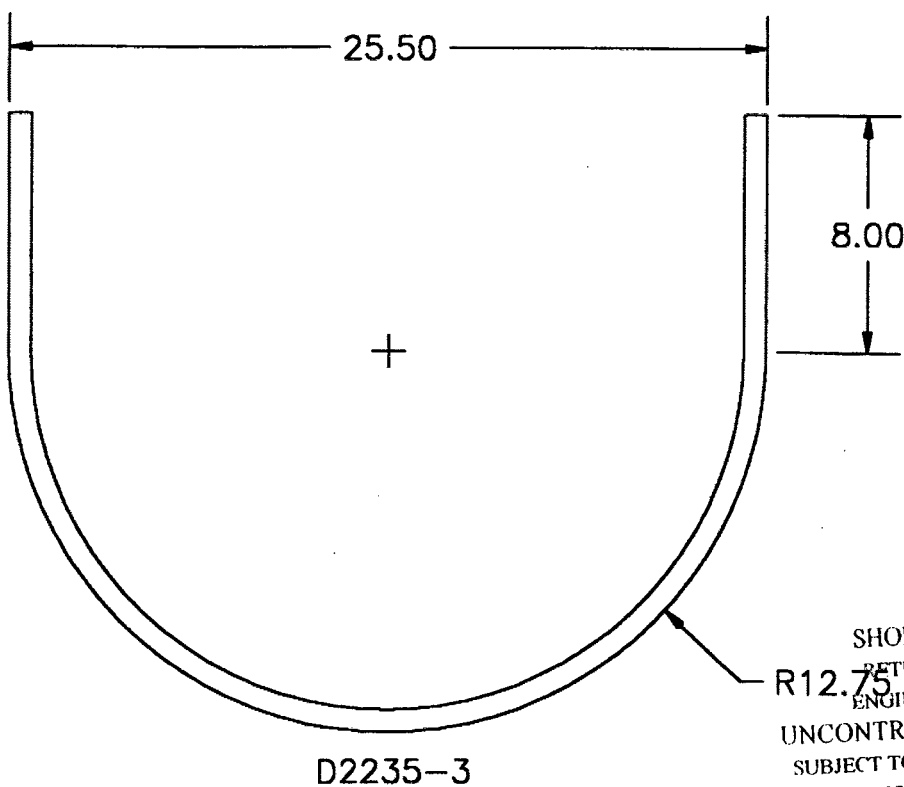
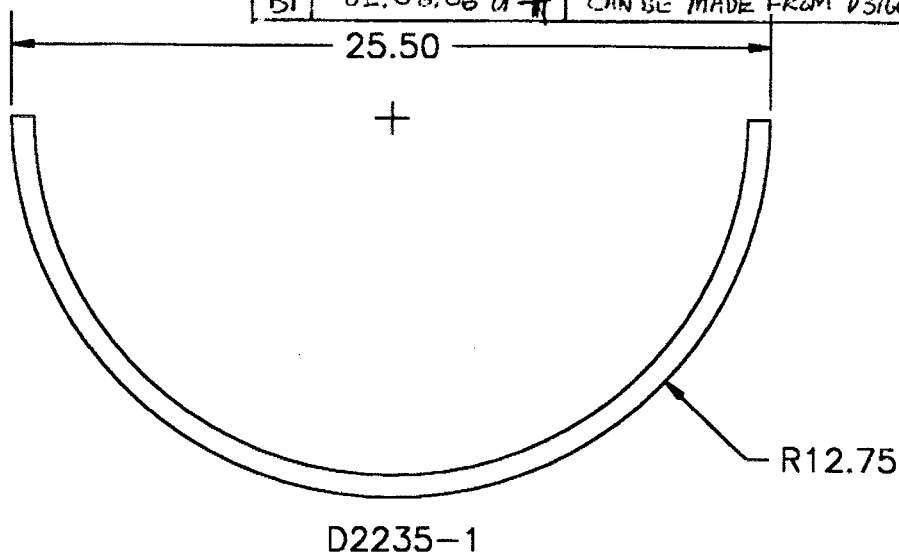
**RELEASED**  
 08 05 21 144

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. 8
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06 <i>U/H</i>	CAN BE MADE FROM D3166-1	

RELEASED  
R 960507



CAN BE MADE FROM D3166-1 *BI*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL NO. *184902*  
SQR.

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